

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008685**Date Inspected:** 20-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Lv Li Qing / Shen Fu You**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Tim McClendon was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG Bay No. 14

This Quality Assurance Inspector (QA) observed that the contractor appears to creating stress concentrations on assembly 9AE – PP73 – 004/005 by applying two, five ton weights in order to achieve the required root opening between Deck Panel Diaphragms and Floor Beam. See photograph for additional information. An incident report will be written on this issue.

Flux Cored Arc Welding (FCAW) on Floor Beam FL 1 to FL 2-2 Complete Joint Penetration weld of weld joint SEG 054 SSD020A – PP79 for OBG weld number 131 for Segment 9CE. The ZPMC welder identified as 044795 was welding in the 3G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Flux Cored Arc Welding (FCAW) on Floor Beam FL 1 to FL 2-2 Complete Joint Penetration weld of weld joint SEG 054 SSD020 – PP79 for OBG weld number 135 for Segment 9CE. The ZPMC welder identified as 055491 was welding in the 3G position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and

WELDING INSPECTION REPORT

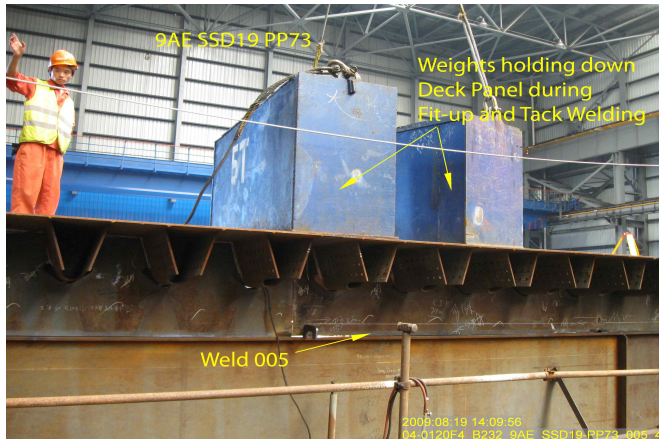
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recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Flux Cored Arc Welding (FCAW) on Floor Beam FL 1 to FL 2-2 Complete Joint Penetration weld of weld joint SEG 054 SSD020 – PP79 for OBG weld numbers 129/130 for Segment 9CE. The ZPMC welder identified as 044795 was welding in the 3F position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2133.

Flux Cored Arc Welding (FCAW) on Floor Beam FL 1 to FL 2-2 Complete Joint Penetration weld of weld joint SEG 054 SSD020 – PP79 for OBG weld numbers 125/126 for Segment 9CE. The ZPMC welder identified as 044795 was welding in the 3F position. The ZPMC QC identified as Zhang Xian Ji was monitoring the welding and recording the weld variables. The welding variables recorded by ZPMC QC appeared to comply with the WPS-B-T-2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations spoken on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	McClendon, Timothy	Quality Assurance Inspector
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Reviewed By:	Patterson, Rodney	QA Reviewer
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